



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D212-664-201
Job Sheet 198974



Part No: D212-664-201

Job Qty: 1 pcs

Part Name: Aft Crosstube - High



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/8/19

Job Tracking No:

Due Date: 8/29/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: IIN-D212-664 REV.J/ D212-664-241 REV E IPP Rev:E 04.02.16 Reformat K/DS IPP Rev:F 06-03-29 Remove
Comments on Pick List JLM IPP Rev:G 07-04-30 As per Rev C JLM IPP Rev:H 08-05-22 up date Qty of rubber
cushion DD ver:EC IPP REV:I 14.05.27 AS PER ECN14-570 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Sign-off
120	Crosstubes - Bend - 1	1 pcs	8/29/19	8/29/19	0.00	1.00	Crosstubes - Bend	DB 8/21/2019
130	QC 15	1 pcs	8/29/19	8/29/19	0.00	0.00	QC 15 - 12	
							QC 15 - 3	
							QC 15 - 47	
							QC 15 - 49	
							QC 15 - 58	
							QC 15 - 9	
							QC 15 - 68	
140	Crosstubes - 2 - B4B	1 pcs	8/29/19	8/29/19	0.00	2.00	Crosstubes - 1 - B4B	AUG 21 2019 68 9-89
							Crosstubes - 2 - B4B	DB 8/22/2019
							Crosstubes - 3 - B4B	
							Crosstubes - 4 - B4B	
150	Crosstubes - 3 - B4B	1 pcs	8/29/19	8/29/19	0.00	1.00	Crosstubes - 1 - B4B	
							Crosstubes - 2 - B4B	DB 8/22/2019
							Crosstubes - 3 - B4B	
							Crosstubes - 4 - B4B	
160	QC 7	1 pcs	8/29/19	8/29/19	0.00	0.00	QC 7 - 10	
							QC 7 - 13	
							QC 7 - 14	
							QC 7 - 15	
							QC 7 - 17	
							QC 7 - 18	
							QC 7 - 19	
							QC 7 - 2	
							QC 7 - 28	
							QC 7 - 3	
							QC 7 - 30	
							QC 7 - 34	
							QC 7 - 36	
							QC 7 - 37	

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D212-664-201/198974/5207467

				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	AUG 26 2019 68
				QC 7 - 50	9-89
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
170	QC 5	1 pcs	8/29/19	0.00 0.00	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	AUG 26 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
180	Outsource - 2 - NDT per QSI038	1 pcs	8/29/19		
				SKY002-VC	5
				AUG 28 2019	
190	Packaging 2-1 - Receive - B4B	1 pcs AC	8/29/19	0.00 0.00	
				Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	

					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
200	QC 5	1 pcs	8/29/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS AUG 30 2019 68
					QC 5 - 9	9-89
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
210	Spray Paint - 2 - B4B	1 pcs	8/29/19	0.00 1.47	Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	RD 19-9-6
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
220	QC 14	1 pcs	8/29/19	0.00 0.00	QC 14 - 15	
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	AS 19-9-7
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
230	Crosstubes - 4 - B4B	1 pcs	8/29/19	0.00 1.47	Crosstubes - 1 - B4B	
					Crosstubes - 2 - B4B	
					Crosstubes - 3 - B4B	
					Crosstubes - 4 - B4B	AS 19-9-8
240	QC 5	1 pcs	8/29/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	

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					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
250	Packaging 1-2 - Pick Kit - B4B	1 pcs	8/29/19	0.00 0.00	Packaging 1 - 1 - B4B	
					Packaging 1 - 2 - B4B	
					Packaging 1 - 3 - B4B	
					Packaging 1 - 4 - B4B	
					Packaging 1 - 5 - B4B	
					Packaging 1 - 6 - B4B	
					Packaging 1 - 7 - B4B	
					Packaging 1 - 8 - B4B	
					Packaging 1 - 9 - B4B	
					Packaging 1 - 10 - B4B	
					Packaging 1 - 11 - B4B	
					Packaging 1 - 12 - B4B	
					Packaging 1 - 13 - B4B	
					Packaging 1 - 14 - B4B	
					Packaging 1 - 15 - B4B	
					Packaging 1 - 16 - B4B	
					Packaging 1 - 17 - B4B	
					Packaging 1 - 18 - B4B	
					Packaging 1 - 19 - B4B	
					Packaging 1 - 20 - B4B	
					Packaging 1 - 21 - B4B	
					Packaging 1 - 22 - B4B	
					Packaging 1 - 23 - B4B	
					Packaging 1 - 24 - B4B	
					Packaging 1 - 25 - B4B	
					Packaging 1 - 26 - B4B	
					Packaging 1 - 27 - B4B	
					Packaging 1 - 28 - B4B	
					Packaging 1 - 29 - B4B	
					Packaging 1 - 30 - B4B	
					Packaging 1 - 31 - B4B	
					Packaging 1 - 32 - B4B	
					Packaging 1 - 33 - B4B	
					Packaging 1 - 34 - B4B	
					Packaging 1 - 35 - B4B	
					Packaging 1 - 36 - B4B	
260	QC 4	1 pcs	8/29/19	0.00 0.00	QC 4 - 28	
					QC 4 - 58	
					QC 4 - 69	
					QC 4 - 9	
					QC 4 - 46	
					QC 4 - 68	
					QC 4 - 72	
					Plex 8/8/19 2:27 PM Dart.lajeunesse.marie	

270	Packaging 3-1 - Stock - B4B	1 pcs	8/29/19	0.00 0.00	QC 4 - 74	
					QC 4 - 75	
					Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
275	DC - 1 - B4B	1 pcs	8/29/19	0.00 0.00	DC - 1 - B4B	SEP 1 6 2019
					DC - 2 - B4B	
280	QC 21 - FG	1 pcs	8/29/19	0.00 0.00	QC 21 - FG - 21	SEP 1 6 2019
					QC 21 - FG - 70	
					QC 21 - SA - 53	

Part Op 120 - NC Bend Crosstube (CNC Alpha 160 Bender) VERF SET-UP BEFORE BENDING BY:

Descriptions: Bend tube as per Dwg D212-664-241 using CNC bender program 212-aft

130 - QC15- Crosstube Dimensional Check)

140 - 1-Drill pilot holes in tube as per Dwg D212-664-241 using drill Jig DT8550, DT8551, drill table DT8577 and locate tower holes #8 as per QSI0010. 2-Rear hole to finish size in tube as per Dwg D212-664-241 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes. 3-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-241 4- ***WEAR LATEX GLOVES HANDLING CROSSTUBE.*** Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-241

150 - HandFinish5 (Crosstubes Chemical Conversion) ***IMMEDIATELY AFTER GRINDING***

160 - QC7-1 (QC7-Inspect Chemical Conversion Coat)

170 - (QC5- Inspect part completeness to step on W/O)

180 - ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Issue P/O: _____ LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2

190 - (Receive & Inspect for Damage & Mat'l Certs) ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.***

200 - QC5- Inspect part completeness to step on W/O) ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Inspect for damage & ensure results are as per Dwg D212-664-241

210 - Spray Paint (Spray Paint / NDT Room) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE***

220 - (QC14- Inspect Spray Paint) Then, Wrap in plastic bag to protect from scratches

230 - (Crosstube) *****LAY DOWN CORSTUBE ON TABLE AND PUT DT10302 PINS IN SADDLE HOLE FACING UP,

DAS
70
8-89

F9/103

85, net
5134223

Clear
5134743
white
204428

USE HOLE IN TAPE MEASURE TO PUT IN PINS FOR LOCATING CENTER OF CROSSTUBE. ***** 1- Abrade mating surfaces of support and crosstube with 180 grit sandpaper, clean the area with MEK or equivalent as per dwg 2- Install supports with Proseal 890 per D212-664-241 and QSI 015 A/R Proseal 890 Batch: 5176610
 EXP: 10/19 PROSEAL CURE TIME 72 HOURS: Start: 19-9-8
 Finish: 19-9-11 3- Install clamps with rubber cushion (ENSURE CLAMPS ARE INSTALL ON TOP SIDE OF CROSSTUBE) using DT9565 as per Dwg D212-664-241. ***Torque all clamps to 80-100 IN-LBS.***
 240 - QC5 (QC5- Inspect part completeness to step on W/O) ***RE-CHECK TORCQUE ON CLAMP AFTER PROSEAL HAS CURED FOR 72HOURS AS PER DWG.***
 250 - Packaging1-3 (Pick Kit)
 260 - QC4 (QC4- 100% Inspect kits for completeness ***VERIFY BY _____ BATCH # TO MATCH W/O
 270 - Packaging3-1 (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPP D212-664-201 Location : FG098
 275 - (Document Control) Photocopy bluefile and create labels as per PPP D212-664-201 CHG006
 280 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D212-664-201TRN	Crosstube Turning Detail	1 pcs (1 ea)	120-Crosstubes - Bend - 1	<u>522530</u>
D2940-1	Support	2 pcs (2 ea)	230-Crosstubes - 4 - B4B	
D3595-063-530	Rubber Cushion 0.63" Wide X 5.30" Long	4 pcs (4 ea)	230-Crosstubes - 4 - B4B	
MS21920-28	Clamp	4 Ea (4 ea)	230-Crosstubes - 4 - B4B	
AN6-40A	3/8-24 Bolt X 3" Long	4 Ea (4 ea)	250-Packaging 1-2 - Pick Kit - B4B	<u>3133179</u>
AN6-41A	Bolt	2 Ea (2 ea)	250-Packaging 1-2 - Pick Kit - B4B	<u>3149318</u>
D3428-1	Placard	1 pcs (1 ea)	250-Packaging 1-2 - Pick Kit - B4B	<u>3140317</u>
MS21042L6	Nut	6 Ea (6 ea)	250-Packaging 1-2 - Pick Kit - B4B	<u>3145406</u>
NAS1149D0663J	Washer	18 Ea (18 ea)	250-Packaging 1-2 - Pick Kit - B4B	<u>3147525</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Crosstubes - Bend - 1	D212-664-201TRN	1	8	0
230-Crosstubes - 4 - B4B	D2940-1 <u>5172579</u>	②	20	0
	D3595-063-530 <u>5180585</u>	④	27	0
	MS21920-28 <u>5171291</u> ①	4 <u>5175780</u> ①	114	0
250-Packaging 1-2 - Pick Kit - B4B	AN6-40A	4	61	0
	AN6-41A	2	35	0
	D3428-1	1	15	0
	MS21042L6	6	264	0
	NAS1149D0663J	18	630	0

Part Specifications

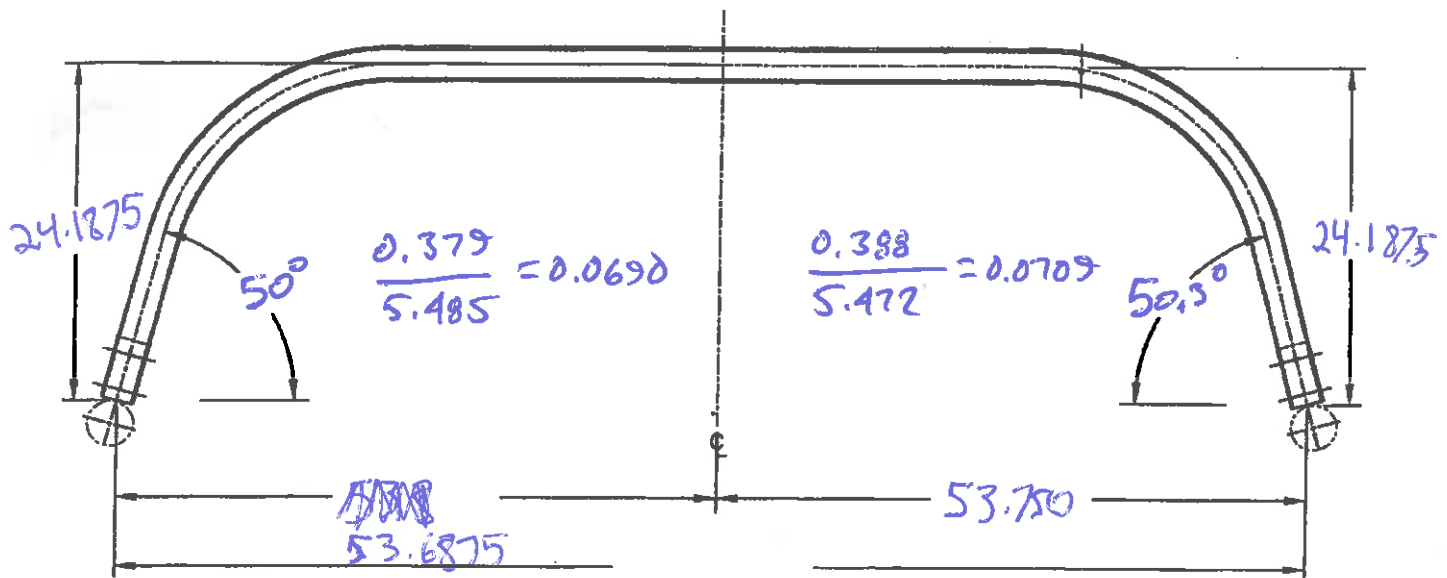
Specifications could not be found.

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198934

DART AEROSPACE LTD		Work Order:	197819
Description: Crosstube High Aft (205/212)		Part Number:	D212-664-201
Inspection Dwg: D212-664-241 Rev: E		Page 1 of 1	

Required Dimension	Min	Max
Height	24.17	24.43
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70
Bending Passes	5	—
Crushing	—	7.2%



2.553
2.932

	Side A	Side B
Bending Passes		
Crushing	6.9%	7.1%
Comments		

2.542
2.930

QC15 Inspection	DAS
Date	68
	AUG 21 2019 9-89

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. C	KJ/JLM	
C	10.04.01	Dwg Rev updated	KJ	
D	12.04.16	Added bending, crushing dimensions	KJ	
E	14.07.08	Crushing percentage revised	KJ	

Item	Qty	Qty	Part Number	Description
	-241	-241B		
1	X		D212-864-241	CROSSTUBE ASSEMBLY (205212 HIGH AFT)
2		X	D212-864-241B	CROSSTUBE ASSEMBLY (214 HIGH AFT)
3	1	1	D6008-129	CROSSTUBE
4	2		D2940-1	SUPPORT
5	4	4	D3595-083-530	RUBBER CUSHION
6		2	D5018-1	SUPPORT
7	4	4	MS21920-28	CLAMP (OR MS21920-30)
8	AR	AR	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6008-129
FINISHED LENGTH = 124.38250.020
- FINISH: a) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
b) PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
c) MASK UNDERSIDE OF CROSSTUBE AS SHOWN (ZN C8-2 / C8-3, HATCHED AREA)
d) PAINT OUTSIDE PER DART QSI 005 4.2
e) REMOVE MASKING AND APPLY MATTE CLEAR COAT
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER 'D212-864-XXX' AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: D212-864-241-241B = 44.2 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- MACHINING
10) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- BENDING
11) BEND PROGRESSIVELY WITH A MINIMUM OF 5 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 7.2% (BASED ON O.D.) IN LOWER HALF OF R33.5 BEND AND 6% (BASED ON O.D.) ON REMAINING TUBE.
12) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- ASSEMBLY
13) INSTALL D2940-1 / D5018-1 SUPPORT: ABRASE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
14) INSTALL MS21920-28 CLAMPS (OR -30) WITH D3595-083-530 RUBBER CUSHIONS TO SECURE THE SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE ON TOP SIDE OF CROSSTUBE.
15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.

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SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

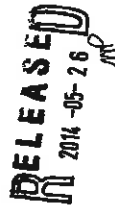
NO. ~~198974~~ 198974

198974 1907-17

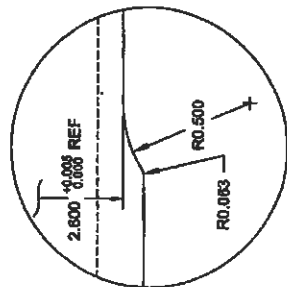
RELEASED
2014-05-28

E	D5018-1 WAS D2940-1 (241B). PROSEAL WAS MAGNIBOND. NOTE 2: ADD INSPECTION WINDOW. NOTE 11: ALLOW 7.2% CRUSH. NOTE 16: ADD 72HR CURE AND RETORQUE FOR PROSEAL. ADD SHEET 3. CLAMPS REVERSED TO PREVENT CHAFING (ZN B7-2, B7-3). BEND HEIGHT TOL. NOW 0.25 WAS 0.13 (C1-4). INCRP DEC D-1/2	CP	14.04.01
D	REFORMAT/REVIEW GENERAL NOTES/PART LIST. REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. ADD -241B (ZN D4-2, B4-2). REMOVED REF A ADD TOLERANCES (ZN D4-3, C4-3). C8-3 & A6-3: RELOCATED FLAG #6 PER PAR 08-048 (ZN A4-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4	RF	06.09.30
C	REMOVE -1008 ABRASION STRIP. ADD MAGNIBOND 638L CUSHION. REVERSE CLAMPS	PH	07.03.08
B	ADD HOLES FOR COMPATIBILITY WITH BHTIAA	PH	06.02.04
A	810TUBES	CP	06.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.	DW	D212-864-241	REV. E
APPROVED			SHEET 1 OF 6
DE APPR.			SCALE
DATE	14.04.01		CROSSTUBE ASSY (205212 HI AFT) NTS
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DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA



SECTION G-G
SCALE 4X



DESIGN	00	DART AEROSPACE LTD HANESBURY, ONTARIO, CANADA		
DRAWN	00	DRAWING NO.	REV. E	
CHECKED	00	D212-864-241	SHEET 5 OF 8	
MFG. APPR.	00	TITLE	SCALE	
APPROVED	00	CROSSTUBE ASSY (205/212 HI AFT)	NTS	
DE APPR.	00			
DATE	14.04.01	CONFIRMED @ 3000W BY DART AEROSPACE LTD DRAWING NO. D212-864-241 PART NO. 205/212 HI AFT DRAWING OF CROSSTUBE ASSY (205/212 HI AFT)		

DETAIL E:
TAPER RUN-OFF
NOT TO SCALE

DETAIL F:
CUFF TRANSITION
SCALE 1/8" = 1'-0"

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION			DEPARTMENT/PROCESS								
		Rework ☐ Scrap ☐ Use-as-is ☐			Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐		
Date :	Sequence #:	QTY Affected :		MRB (QS1042)									
Description Work Order Deviation		Disposition											
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY											
		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐		Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐					
		Other/Details: _____											
		Completed By											
		Lead hand / Supervisor											
		QC / QA Coordinator											



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044352



Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

Attention: Jenne, Heather

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044352

PO Date: 8/26/19

Due Date: 8/28/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	198971	D212-664-201	Aft Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17 ***WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE.*** Issue P/O: LIQUID PENETRANT INSPECTION AS PER QSI 038 OR LPI AS PER ASTM 1417 LEVEL 2	Firmed	-	8/28/19	1 pcs	0 pcs	1 pcs	\$140.7142/pcs	\$140.71
	198972	1	X AUG 2 8 2019	Firmed	-	8/28/19	1 pcs	0 pcs	1 pcs	\$140.7142/pcs	\$140.71
	198974	1	X AUG 2 8 2019	Firmed	-	8/28/19	1 pcs	0 pcs	1 pcs	\$140.7142/pcs	\$140.71
	198976	1	X AUG 2 8 2019	Firmed	-	8/28/19	1 pcs	0 pcs	1 pcs	\$140.7142/pcs	\$140.71
	198979	1	X AUG 2 8 2019	Firmed	-	8/28/19	1 pcs	0 pcs	1 pcs	\$140.7142/pcs	\$140.71
Sub Total:							5	0	5		\$703.57



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PURCHASE ORDER

POHB044352



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	199335	D212-664-101B	Fwd Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17 (Outsource process - NDT per QSI038 4.1) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	8/28/19	1 pcs	0 pcs	1 pcs	\$140.7142/pcs	\$140.71
3	199277	D212-664-201B	Aft Crosstube - High : TC STC SH01-9 Issue 3, FAA STC SR01298NY 09/01/08, EASA STC EASA.IM.R.S.01304 07/03/06, DGAC MEXICO STC IA-316/2015 15/06/17 (Outsource process - NDT per QSI038 4.1) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038 Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order	Firmed	-	8/28/19	1 pcs	0 pcs	1 pcs	\$140.7142/pcs	\$140.71
Grand Total:										\$985.00	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/28/19 2:38 PM Dart.Guerin.Kimberley

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO41555	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: POHB044352
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:**CARRY OUT NDT ON:**

- ✓ 5 AFT CROSSTUBES, P/N: D212-664-201, J/S: 198971, 198972, 198974, 198976, 198979
- ✓ 1 AFT CROSSTUBE, P/N: D212-664-201B, J/S: 199277
- ✓ 1 FWD CROSSTUBE, P/N D212-664-101B, J/S: 199335

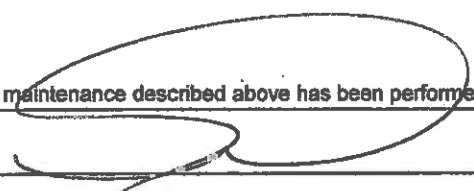
Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-16						AUG 28 2019	 
NO CRACK FOUND							
PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923, DEV. MPO11715, UV LIGHT M-20142							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

In house
RECEIVED

AUG 28 2019

DART AEROSPACE LTD.

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp 	Date: AUG 28 2019
Name: HAFIN MELIKIAN		

SKYM002-1 REV 5 Apr/17

5.0 PARTS LIST

5.1 HIGH GEAR CROSSTUBES

Item	QTY -101	QTY -201	QTY -203	Part Number	Description
	X			D212-664-101	CROSSTUBE INSTALLATION, 204/205/210/212/214/412, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH FWD
		X		D212-664-201	CROSSTUBE INSTALLATION, 204/205/210/212/214, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH AFT
			X	D412-664-203	CROSSTUBE INSTALLATION, 412 HIGH AFT
1	1			D212-664-141	CROSSTUBE ASSEMBLY, 204/205/210/212/214/412, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH FWD
2		1		D212-664-241	CROSSTUBE ASSEMBLY, 204/205/210/212/214, UH-1H, UH-1A/B/E/F/L/P, TH-1F/L, HH-1K HIGH AFT
3			1	D412-664-243	CROSSTUBE ASSEMBLY, 412 HIGH AFT
10	2			* D2893-1	SUPPORT
11	4			* D3595-063-450	RUBBER CUSHION
12	4			* MS21920-25	CLAMP (OR MS21920-26)
13	4			AN6-35A	BOLT
14	4			AN6-36A	BOLT
15	6			MS21042L6	NUT (OR MS21042-6)
16	18			AN960JD616	WASHER
20		2		* D2940-1	SUPPORT
21		4		* D3595-063-530	RUBBER CUSHION
22		4		* MS21920-28	CLAMP (OR MS21920-30)
23		4		AN6-40A	BOLT
24		4		AN6-41A	BOLT
25		6		MS21042L6	NUT (OR MS21042-6)
26		18		AN960JD616	WASHER
30			1	* D2896-1	SUPPORT
32			2	* D3595-063-570	RUBBER CUSHION
33			4	* MS21920-28	CLAMP
34			2	* MS21920-30	CLAMP (OR MS21920-32)
35			4	AN6-40A	BOLT
36			2	AN6-41A	BOLT
37			6	MS21042L6	NUT (OR MS21042-6)
38			18	AN960JD616	WASHER
39			2	* D3189-1	CHAFING SHIELD
50	1	1		D3428-1	PLACARD

* REFERENCE ONLY. PARTS ARE INCLUDED IN D212-664-141/-241 OR D412-664-243 ASSEMBLIES ABOVE.

NOTE: KITS INCLUDE EXTRA HARDWARE FOR COMPATIBILITY WITH BOTH DART AND BELL/AAI SKIDTUBES.

Change Record

PAGE 1 OF 1

Part Number: D212-664-201/-201MB

Description: CROSSTUBE INSTALLATION, HIGH AFT

[illegible]